

Work Order ID 59536

Monday, June 07, 2010 10:39:16 AM



Page 1

Item ID: D4016-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half, Base

Start Date: 6/7/2010 Start Qty: 9.00



Cust Item ID:

Required Date: 6/21/2010 Req'd Qty: 9.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

6/6/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

*2010/06/11**9 8*

Jeaspa Bandsaw

CUT BLANK 1.00" LONG

110

0.00



HAAS 1

Memo

0.00

*2010/06/14**9 8*

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV: *AA*DWG REV: *A*

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 6/7/2010 Start Qty: 9.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>28.06/14</i> <i>ang</i>		<u>9</u>	<u>0</u>		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>mmj</i> <i>10/06/15</i>		<u>9</u>	<u>0</u>		
160 Packaging Packaging	Identify as per dwg & Stock Location: <i>Steve</i> Memo	0.00 0.00				<u>10-6-15</u>		<u>(909)</u>	

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Monday, June 07, 2010 10:39:16 AM

Item ID: D4016-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Hinge Half, Base
Start Date: 6/7/2010 Start Qty: 9.00  Cust Item ID:
Required Date: 6/21/2010 Req'd Qty: 9.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/06/15 

11/10/15
(9)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, June 07, 2010 10:39:21 AM

Page 1

Work Order ID: 59536



Parent Item: D4016-1



Parent Item Name: Hinge Half, Base

Start Date: 6/7/2010

Required Date: 6/21/2010

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

Start Qty: 9.00

Required Qty: 9.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	11.1422	0.08	0.757895			



304 bar 1.50 X1.50



Location

Loc Qty

Loc Code

MAT54

11.14220368

→ 108381

10.4841

112752

0.65810368

0.7578 *ml 10/06/11*

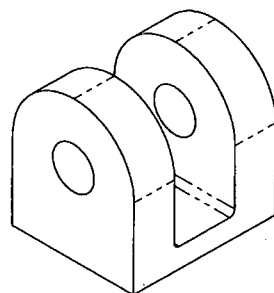
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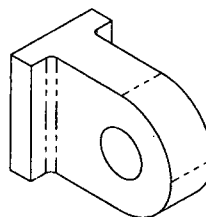
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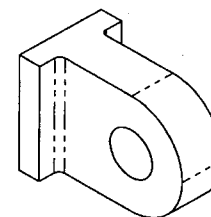
NOTE: Date & initial all entries



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

59536

RELEASED
2010-02-16
MD

A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	RS	DRAWING NO.	REV. A
MFG. APPR.	MD	D4016	SHEET 1 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

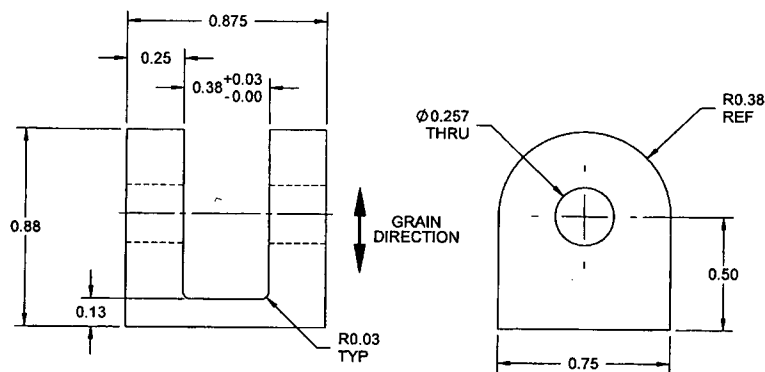
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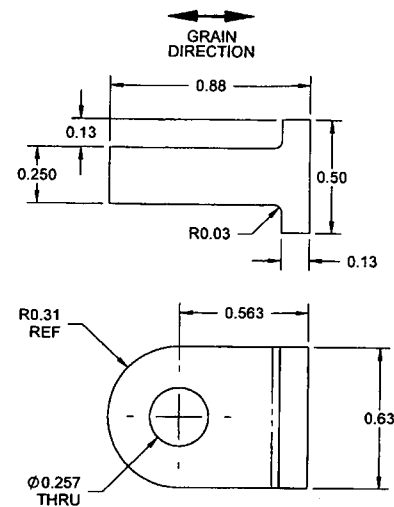
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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED





5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4016	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET HINGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-02-16
[Signature]

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